Work Order ID 121861

Wednesday, July 02, 2014 3:37:29 PM

121861

Item ID: D3874-2L08 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Floor Protector, Pilot (Clear) **Stop** *NS2*

Start Date: 7/04/14 **Start Qty:** 4.00 *4*

Required Date: 7/09/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3874	**Revision Nbr** B Dtw								
100		0.00							DAS 07 9-89
100									
HandThermo	**Memo**	0.00				x4			
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								14/07/10
105		0.00							DAS 07 9-89
105	Dry Material								
HandThermo	**Memo**	0.00				x4			
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								14/07/10

Temp: 245 deg. F

Time IN: 5:00 PM JUL 10 2014

Time OUT: 6:00 AM

Per.....

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D3874-2L08 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Floor Protector, Pilot (Clear)
Start Date: 7/04/14 **Start Qty:** 4.00 *4*
Required Date: 7/09/14 **Req'd Qty:** 4.00 *4*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110						x4			14/07/10
Thermoform	**Memo**	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA039 using tool DT9474 Dwg Rev: B Folio Rev: A Visually inspect for proper formation and texture								
140		0.00							DAS 07 9-89
140						x4			14/07/16
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
150						x4			14/07/16
QC	**Memo**	0.00							
Quality Control	Complete FAI document								

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Item ID: D3874-2L08 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID:
Item Name: Floor Protector, Pilot (Clear) **Stop** *NS2*
Start Date: 7/04/14 **Start Qty:** 4.00 *4*
Required Date: 7/09/14 **Req'd Qty:** 4.00 *4*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00 DAS 27				4			
160 QC Quality Control	**Memo**	0.00 9-89 14-7-16							
170	Identify as per dwg & Stock Location: PPP	0.00 2X121769				4X SP 14-7-18			
170 Packaging Packaging	**Memo**	0.00 2X121770.							
180	QC21- Final Inspection - Work Order Release	0.00				MLJ 14-07-21			
180 QC Quality Control	**Memo**	0.00				14-7-18			

DQA: _____ Date: _____

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☐ Other _____

Picklist Print

Wednesday, July 02, 2014 3:37:29 PM

Work Order ID: 121861 *121861*

Parent Item: D3874-2L08 *D3874-2L08*

Parent Item Name: Floor Protector, Pilot (Clear)

Start Date: 7/04/14 **Required Date:** 7/09/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev C Added Color to D3874-2 14/07/02 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,885.788	4.38	19			DAS 07 9-89
MLEXS.118-90318-08									**				
Lexan Sheet													

14/07/10

Location	Loc Qty	Loc Code
therm	2885.788	
113127	8	
m126994	2877.788	

19 sq ft.

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data	☐									
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Operator	☐									
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Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
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DART AEROSPACE LTD	Work Order:	121861
Description: Floor Protector	Part Number:	D3874-2
Inspection Dwg: D3874 **Rev:** ~~A~~ B wh		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than N/A"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	~~DAS~~ 07 ~~9-89~~	Date:	14/07/16

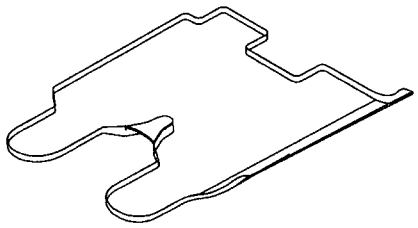
TRIMMING SECTION

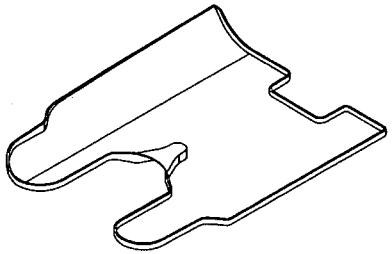
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.064"	✓			
0.065	Min	0.077"	✓			
0.5	Min	0.53"	✓			
21.9	REF	21.94"	✓			

Measured by:	~~DAS~~ 07 ~~9-89~~ DAS	Date:	14/07/16
Audited by:	~~27~~ 9-89	Date:	14/7/16
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121861 MCS
1407-04





B D3874-1LXX FLOOR PROTECTOR

B D3874-2LXX FLOOR PROTECTOR

RELEASED
2014 -06- 17

REV.	DESCRIPTION	BY	DATE
B	ADDED D3874-1L02 AND D3874-2L02 CONFIGURATIONS AND RE-IDENTIFIED D3874-1 AND D3874-2 AS D3874-1L08 AND D3874-2L08. REVISED NOTE 1 AND ADDED MATERIAL TABLE.	AK	14.04.10
A	NEW ISSUE	PH	09.01.29

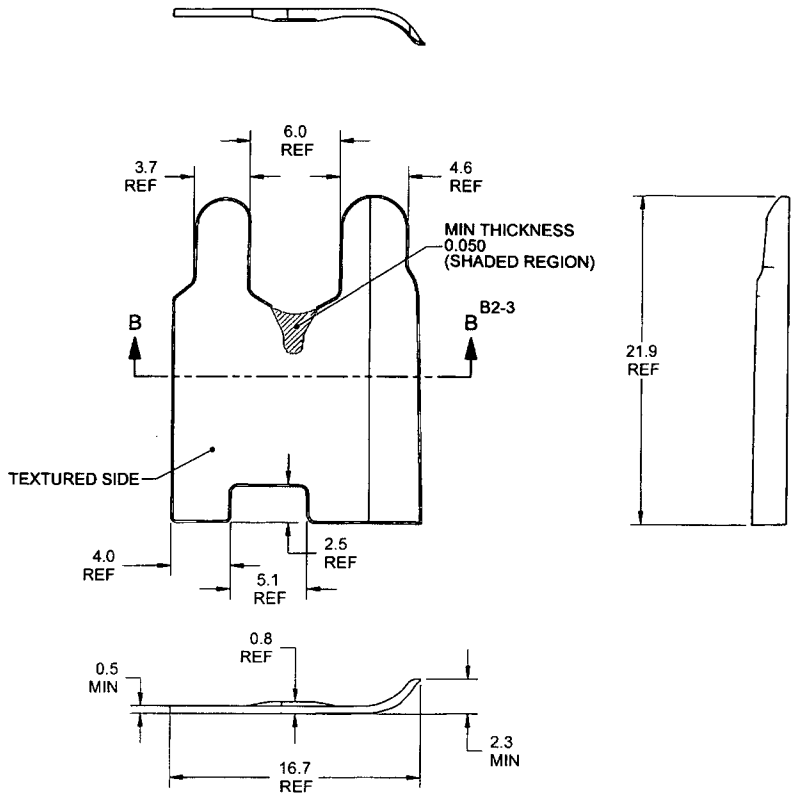
APPROVED

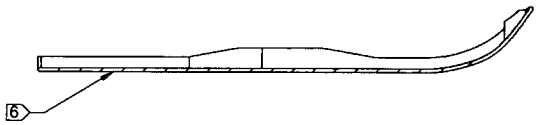
DESIGN	AK
DRAWN	AK
CHECKED	RF
MFG. APPR.	DL
APPROVED	HS
DE APPR.	DS
DATE	14.04.10

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3874 REV. B
SHEET 1 OF 3
TITLE FLOOR PROTECTOR SCALE NTS

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C5-3

SECTION B-B
SCALE 2X

B D3874-2LXX FLOOR PROTECTOR

RELEASED
2014 -06- 17

NOTES:
1) MATERIAL: SEE TABLE B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2LXX" USING VIBRATING STYLUS
7) WEIGHT: 1.5 lbs
8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

B

PART NUMBER	DESCRIPTION
D3874-2L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEX.125-F6006-02)
D3874-2L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEX.118-90318-08)

APPROVED

DESIGN	AK	DART AEROSPACE LTD
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D3874 REV. B
MFG. APPR.	DL	SHEET 3 OF 3
APPROVED	HS	TITLE FLOOR PROTECTOR SCALE NTS
DE APPR.	DS	
DATE	14.04.10	

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